

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019922**Date Inspected:** 04-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. LI YAN HUA**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector Santhosh Ramakrishna was present during the times noted above for observations relative to fabrication work of the Self Anchored Suspension (SAS) Superstructure being performed.

This QA inspector randomly observed the following work:

1. INPROCESS:

Orthotropic Box Girder (OBG) at Bay-14 Area:

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the deck panel diaphragm to floor beam weld joint located on 13CE at Panel Point (PP-122.5). The weld is designated as SEG3011K-006. The welder is identified as 052696. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, current 290.6 Amps, Voltage 26.4 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the deck panel diaphragm to floor beam weld joint located on 13BE at Panel Point (PP-122). The weld is designated as SEG3009B-006. The welder is identified as 188990. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, current 295.2 Amps, Voltage 25.1

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Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2232-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the side plate to corner assembly weld joint located on 13BE in between Panel Point (PP-120.5 & PP-121). The weld is designated as SEG3009M-001. The welder is identified as 066041. ZPMC QC Mr. ZHONG YONG HONG was onsite monitoring the welding variables. The welding variables were recorded at, current 275.8 Amps, Voltage 26.2 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2231-ESAB.

ZPMC welding personnel performing Flux Core Arc Welding of Repair weld for the edge plate to side plate weld joint located on 13AE at bike path side. The weld is designated as SEG3007AB-099. The welder is identified as 050242. ZPMC QC Mr. ZHANG QIANG was onsite monitoring the welding variables. The welding variables were recorded at, current 295.0 Amps, Voltage 23.9 Volts. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-345-FCAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as WR-20221. Further weld detail mention in attached picture.

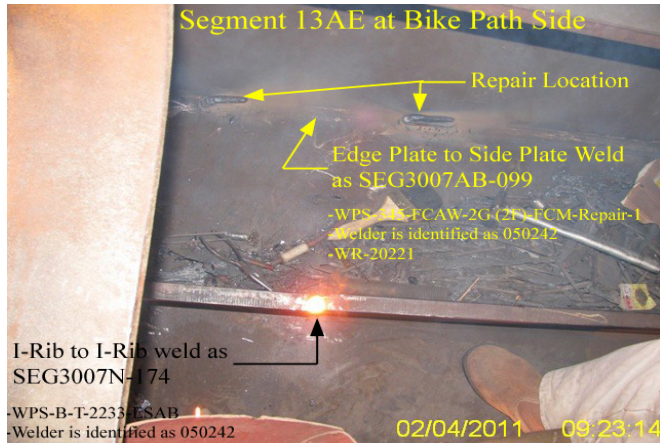
ZPMC welding personnel performing Flux Core Arc Welding of Complete Joint Penetration welds joining the I-Rib to I-Rib weld joint for side plate located on 13AE at bike path side. The weld is designated as SEG3007N-174. The welder is identified as 050242. ZPMC QC Mr. ZHANG QIANG was onsite monitoring the welding variables. The inprocess Flux Core Arc Welding appears to be progressing in compliance with WPS-B-T-2233-ESAB. Further weld detail mention in attached picture.

ZPMC welding personnel performing Shielded Metal Arc Welding of Repair weld for the deck plate to deck panel diaphragm weld joint located on 14E. The weld is designated as DP3163-001-028. The welder is identified as 066326. ZPMC QC Mr. LI YAN HUA was onsite monitoring the welding variables. The inprocess Shielded Metal Arc Welding appears to be progressing in compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1. The weld repair report number is named as WR-20222.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Pillai,Santosh

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer